Work Order February-07-13 8:			*968	330*	,	Sh	ip	Ma Zi	rch	Page 1
Revision ID:	3933-1 I Wall Protector		Accept	*N900				Setup Star Stop	* <b>N</b>	S1* S2*
Start Date: 2/0 Required Date: 3/2 Reference:	O7/13 Start Qty: 12.00 Req'd Qty: 12.00	1 /		Cust Item Customer:						.7/
	rocess Plan: MLゴ	Date: <u>/3-0</u> Z-0			ate:		Ą	Run Star Stop	"IV	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr			· · · ·					·	
D3933 100 *100* Waterjet FLOW CNC Waterjet	Dwg Rev:_ Prog Rev:_	A	0.00	<u>-</u>			12			JMB-221
110	2- Deburr  QC2- Inspect parts off	if necessary machine FAl/FAIB	0.00							

0.00

Memo

12 0 Jm13-2-21

\*11**0**\*

Quality Control

											DQA:	Date	•		
NCR: Y	'es	/ No				WORK ORDER NON-	COI	NFORN	MANCE / UPI	DATE	QA Closed:	Date	:		
lura di Ocala						DISPOSITION	DISPOSITION AGAINST DEPA					PARTMENT/PROCESS			
Part N	Work Order:  Part No.  NCR No.				Rework Skid-tube Machining Use-as-is Work Order Update Large Fab			Crosstube Small Fab Finishing Composite	Pro Rec/Sto	Engineering Quality Other					
Root					Descr	iption of work order update	Т	Initial	Ac	tion	Sign &				
Cause	ĺ	Date	Step	Qty		or Non-conformance	CI	nief Eng	Desc	ription	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								LT CATE	CORY						
<u> </u>					<u></u>		FAU	LT CATE	GORY						
Landi	ng (	Bending Centre N Cracks Crushed, Cuffs Heat Tre Inspectic Ripples i	at on Strip in n Bend	n Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misrea Offset	ion Incomplete tions Incomplete/ enance eled d	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N Power Loss	ect lissing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
1	1	Torque \	Naves in	Extrusio	n [	Drawing	Ŀ	_JOut of	Calibration						

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 2

February-07-13 8:23:07 AM Item ID: D3933-1 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Aft Wall Protector **Start Date:** 2/07/13 **Start Qty: 12.00** Cust Item ID: Required Date: 3/22/13 Req'd Qty: 12.00 **Customer:** Reference: Run Approvals: Process Plan: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Number Stamp Qty 120 QC8- Inspect parts - second check OAS \*120\* 19 0.00 Memo Quality Control Identify as per dwg & Stock Location: 57209 0.00 130 \*130\* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 \*140\* 0.00 Memo Quality Control

\$ (2) N. 28

											DQA:	Date	·	
NCR: Y	'es	/ No				WORK ORDER NON-CONFORMANCE / UPDATE								
											QA Closed:	Date	:	
Work Orde	r.					DISPOSITION	İ		AGAII	NST DE	PARTMENT	/PROCESS		
WOIR Olde	- '					Rework			Skid-tube Crossto	ube		Water Jet	Engineering	
Part N	۱o					Scrap		f	Machining Small	Fab	1	d. Eng. Coor.	Quality	
NCR N	۱o. <u>-</u>	· · · · · · · · · · · · · · · · · · ·				Use-as-is Work Order Update			noforming Finish Large Fab Compo		Rec/Store/Packaging Othe Supplier			
Root					Descri	ption of work order update	ŀ	nitial	Action		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
Doc/Data								- "						
Equip/Tooling							ļ							
Operator														
Material														
Setup														
Other														
Process							ļ				İ			
Supplier							ĺ							
Training						*								
Unapproved														
						F	AUL	T CATE	GORY					
Landi	ng G	ear			<u></u>	General				_	,			
		Bending				Bend		Grain			Ovalized	Ļ	Pressure/Forced	
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct _	Weld	
		Crushed/	Crimped			Burrs	L	instruct	ions Incomplete/Unclear		Part Lost/M	issing	Wrong Stock Pulled	
		Cuffs			[	Contamination		Mainte	enance		Part Moved			
		Heat Tre	at			Countersink		Mislabe	eled		Positioned V	Vrong _		
		Inspectio	n Strip ir	Tube		Cut Too Short		Misrea	i	L	Power Loss/	Surge	Other	
		Ripples i	n Bend			Drill Holes		Offset						

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

## **Picklist Print**

February-07-13 8:23:10 AM

Work Order ID: 96830

D3933-1

Parent Item Name: Aft Wall Protector

\*96830\*

\*D3933-1\*

**Start Date: 2/07/13** 

Required Date: 3/22/13

**Start Oty:** 12.00

Required Qty: 12.00

Comments:

Parent Item:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	11.6273	7.01	8472			·- ··· - ·
*MI FXS 1 GE PLASTICS LEXAN SH	25-F60	N29-N4	*						**	128			JMB-2-2

Location Loc Qty Loc Code MAT019 11.6273 11.6273

124655 124654 ×6 Page 1

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** Yes / No NCR: QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Engineering Skid-tube Water Jet Crosstube Rework Prod. Eng. Coor. Quality Machining Small Fab Part No. Scrap Other Thermoforming Rec/Store/Packaging Finishing Use-as-is Supplier Work Order Update Large Fab Composite NCR No. Action Sign & Description of work order update Initial Root **Chief Eng** Date Verification QC inspector Description or Non-conformance Cause Date Step Qty Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Ovalized Pressure/Forced Bend Grain Bending Over/Under tolerance Temperature/Cure BOM/Route Hardware Centre Not Concentric to O/S Part Incorrect Weld Broken/Damaged Inspection Incomplete Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs Part Moved Contamination Maintenance Cuffs **Positioned Wrong** Countersink Mislabeled Heat Treat Other Power Loss/Surge **Cut Too Short** Misread Inspection Strip in Tube Offset **Drill Holes** Ripples in Bend

Out of Calibration

Out of Sequence

**Outside Dimensions** 

**Turning Sequence** 

Wave/Twist in Tube

**Torque Waves in Extrusion** 

Drawing

Finish

Folio

DART AEROSPACE LTD	Work Order:	96830
Description: Aft Cabin Wall Protector, LH	Part Number:	D3933-1
Inspection Dwg: D3933 Rev: A	· · · · · · · · · · · · · · · · · · ·	Page 1 of 1

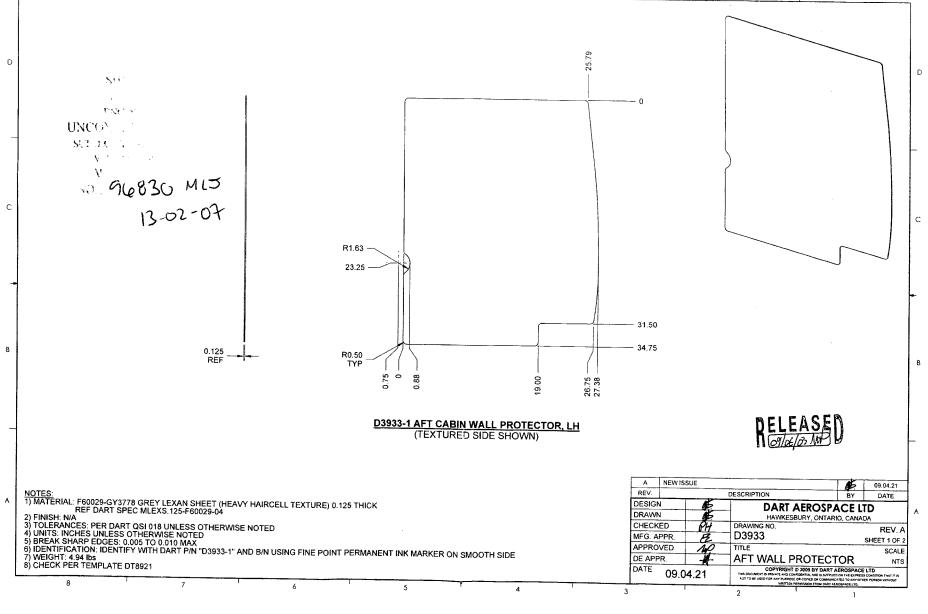
## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimensior	Toleranc	Actual e Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	0.88	-		V	Jkmai
19.00	+/-0.030		-		· T	
26.75	+/-0.030		_		T	
27.38	+/-0.030		_		Т	
34.75	+/-0.030		_		Т	
31.50	+/-0.030		_		T	
25.79	+/-0.030				T	
0.125	+/-0.010		_		· V	.1
23.25	+/-0.030	23.25	-		7	
					1	41111
					<del></del>	
			CAS.			
			48 1			
Measured by:	Jm	Audited by:	9-89		Prototype Ap	proval: N/A

Measured by: JM	Audited by:	Prototype Approval:	N/A
Date: 13-2-21	Date: 13221	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	09.06.22	New Issue	KJ SA	12/



D D С R1.63 23.25 31.50 34.75 0.125 R0.50 REF 38 19.00 D3933-2 AFT CABIN WALL PROTECTOR, RH (TEXTURED SIDE SHOWN) NOTES: 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK REF DART SPEC MLEXS.125-F60029-04 DESIGN DART AEROSPACE LTD 2) FINISH: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MaX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3933-2" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
7) WEIGHT: 4.94 lbs
8) CHECK PER TEMPLATE DT8921 DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3933 MFG. APPR. SHEET 2 OF 2 APPROVED TITLE AFT WALL PROTECTOR DE APPR. DATE COPYRIGHT © 2009 BY DART AEROSPACE LTD

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